

Work Order ID 50279

July 14, 2009 11:34:44 AM





Page 1

Item ID: D3121-043 Accept  Setup Start 
 Revision ID: E Stop 
 Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 4.00  Cust Item ID:
 Required Date: 7/15/09 Req'd Qty: 4.00  Customer:


Reference:

Handwritten: 09-07-15

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3121	Rev E

100	BAND SAW	0.00							
	Bandsaw	Memo	0.00						
Jeaspa Bandsaw	Cut blanks: (1.000" x 2.000") 3.250" long								


Handwritten: SL 09/08/10
Handwritten: mvf 09/08/11

Handwritten: 4

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	Memo	0.00						
HAAS CNC vertical machine #1	1-Machine D3121-13 as per Folio FA329 and Dwg D3121-13 13□2-Deburr□3-Scribe batch number								

Handwritten: SL 09/08/11
Handwritten: mvf

Handwritten: 4

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

Handwritten: SL
Handwritten: mvf 09/08/11

Handwritten: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50279

July 14, 2009 11:34:44 AM



Page 2

Item ID: D3121-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

ml 09/08/11

4

0

Memo

0.00

140



Small Fab

Small Fab

Small Fab

Memo

Assemble D3121-13as per Dwg D3121.

0.00

0.00

09/08/13

(4)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) S 09/09/13

(4)

0

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 50279

July 14, 2009 11:34:44 AM

Page 3

Item ID: D3121-043

Accept

Revision ID: E

Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 4.00

Required Date: 7/15/09 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 235

0.00



Packaging

Memo

0.00

Packaging

9/8/14 (4x) Sef

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/08/17 JF
mf 09-08-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:34:43 AM

Work Order ID: 50279

Parent Item: D3121-043RevE

Parent Item Name: Bracket Assembly


Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-21RevE		Manufactured	No			140	Each	74.0000	8.0000			
												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	74	
46032	17	
46739	17	
50096	40	

D3121-241RevE		Manufactured	No			100	Each	69.0000	8.0000			
												
Bearing Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	69	
46031	9	
46169	60	

M174B1.250X02.000		Purchased	No			140	f	28.5600	1.1389			
												
17-4 SS Bar 1.250 x 2.00												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	28.56	
109851	4.56	
111787	24	

1.00
7/14/09

419478
not in

1.08 J.L 08/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3121-13
Inspection Dwg: D3121	Rev: <i>PE</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	299	✓			
0.080	+/-0.010	078	✓			
0.392	+0.002/-0.000	3928	✓			
0.350	+/-0.010	352	✓			
1.540	+/-0.010	1.542	✓			
R0.250	+/-0.010	0.250	✓			
1.800	+/-0.010	1.802	✓			
1.370	+/-0.010					
1.050	+/-0.010					
0.420	+/-0.010					
0.400	+/-0.010	404	✓			
1.220	+/-0.010	1.220	✓			
2.63	+/-0.030	2632	✓			
2.80	+/-0.030	2.799	✓			
2.48	+/-0.030	2.474	✓			
0.130	+/-0.010	131	✓			
0.300	+/-0.010	298	✓			
0.080	+/-0.010	078	✓			
0.260	+/-0.010	261	✓			
0.032	+/-0.010	026	✓			
0.200	+/-0.010	200	✓			
0.400	+/-0.010	397	✓			
0.381	+/-0.010	383	✓			

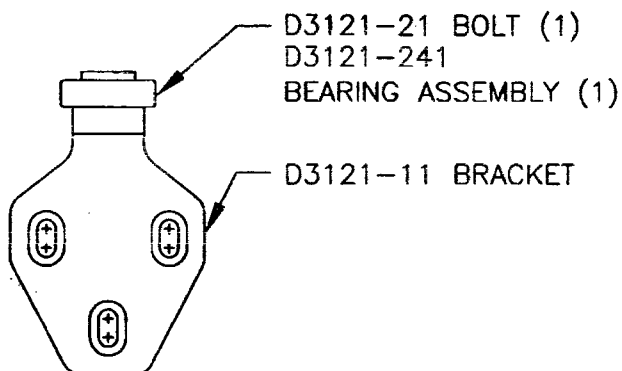
Measured by: <i>JL</i>	Audited by: <i>mf</i>	Prototype Approval:	N/A
Date: 09/08/10	Date: 09/08/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue P/O D3121-043/-044	KJ/JLM	
B	06.06.14	Dwg Rev. updated	KJ/JLM	<i>mf</i>

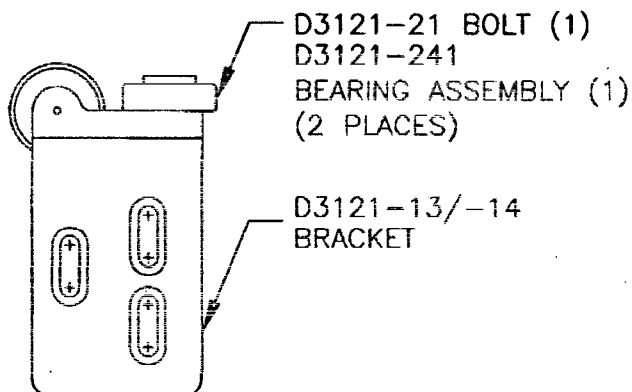


DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

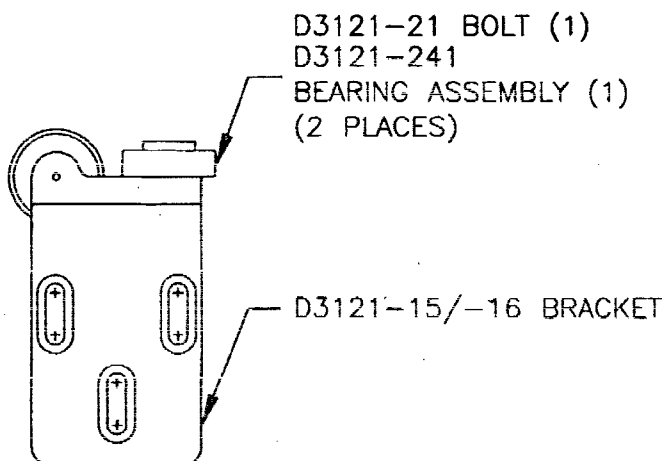
RELEASED
07.11.07



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

50278

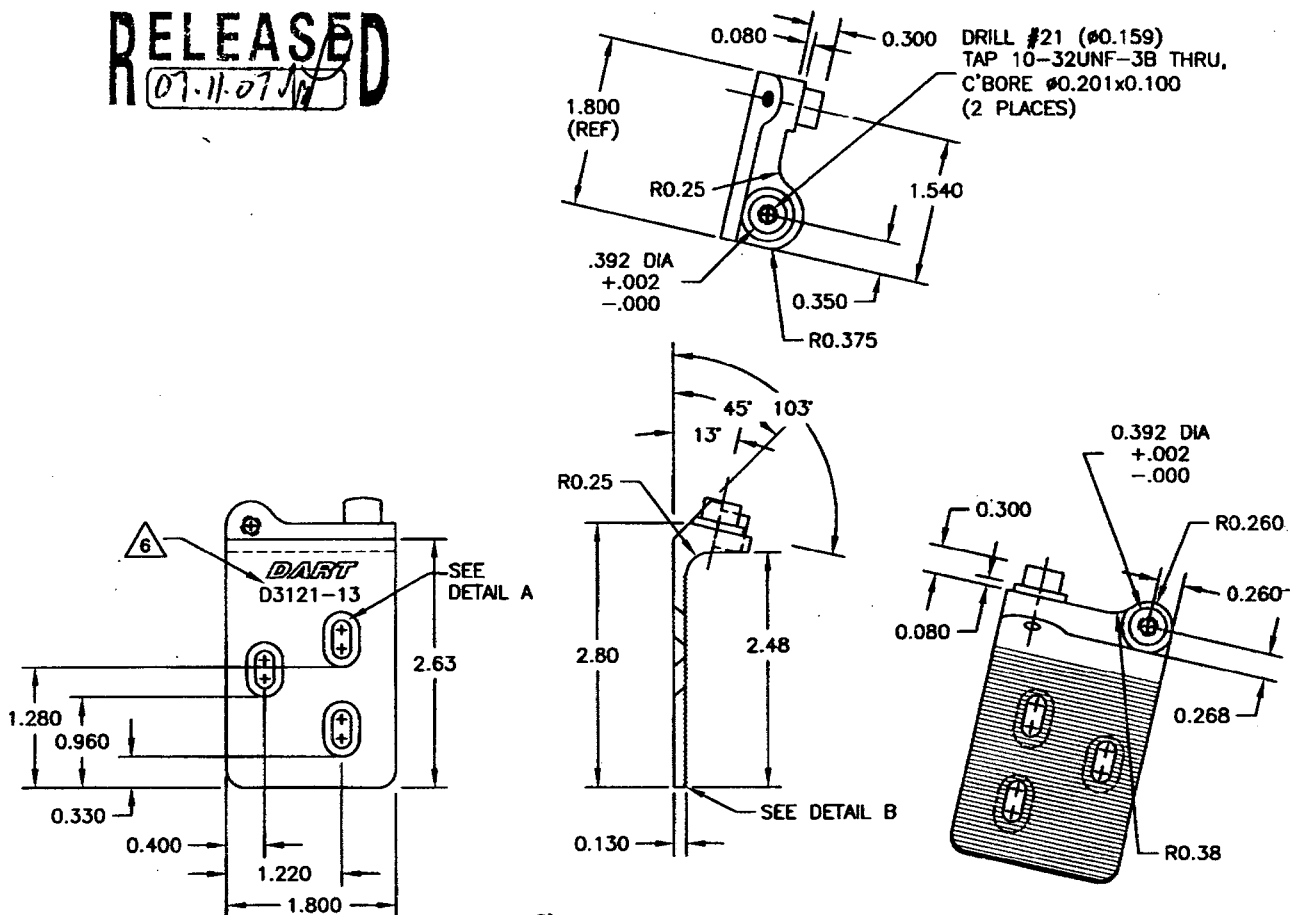
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DESIGN A	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED [Signature]	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-13 BRACKET (SHOWN)

D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

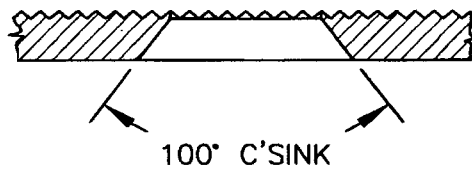
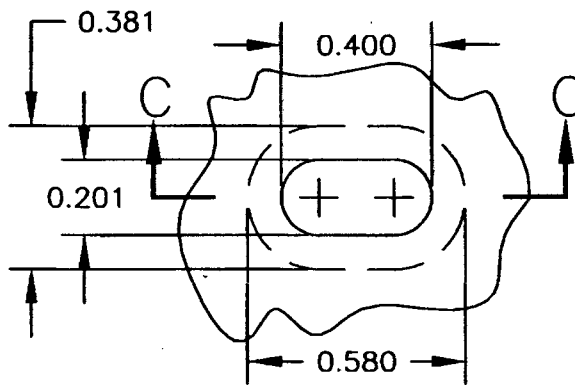
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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20

5-2005

